



Monprene® IN-26990V XRD1 (PRELIMINARY DATA)

Teknor Apex Company - Thermoplastic Vulcanizate

General Information

Product Description

Monprene IN-26990V XRD1 is a high performance thermoplastic vulcanizate designed for a variety of industrial applications. Monprene IN-26990V XRD1 is a low density, high hardness, RoHS compliant grade that is suitable for extrusion and injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Abrasion Resistant • Chemical Resistant • Good Adhesion • Good Colorability • Good Melt Strength • Good Moldability	• Good Processability • Good Processing Stability • Good Tear Strength • Good Toughness • Halogen Free • High Elongation	• High Hardness • Light Stabilized • Low Density • Low Flow • Low Specific Gravity
Uses	• Gaskets • Handles • Hose • Industrial Applications	• Low Temperature Applications • Pipe Seals • Profiles • Rubber Replacement	• Seals • Tubing • Windows & Doors
RoHS Compliance	• RoHS Compliant		
Appearance	• Colors Available	• Natural Color	
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.930		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress ²			ASTM D412
Across Flow : 100% Strain	802	psi	
Flow : 100% Strain	1090	psi	
Tensile Stress ²			ASTM D412
Across Flow : 300% Strain	951	psi	
Flow : 300% Strain	1260	psi	
Tensile Strength ²			ASTM D412
Across Flow : Break	1570	psi	
Flow : Break	1390	psi	
Tensile Elongation ²			ASTM D412
Across Flow : Break	660	%	
Flow : Break	450	%	
Tear Strength ²			ASTM D624
Across Flow	353	lbf/in	
Flow	351	lbf/in	
Compression Set ³			ASTM D395B
73°F, 22 hr	43	%	
158°F, 22 hr	62	%	

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Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A, 1 sec, Injection Molded	93		
Shore A, 5 sec, Injection Molded	91		

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	440 to 480	°F
Middle Temperature	440 to 480	°F
Front Temperature	440 to 480	°F
Nozzle Temperature	440 to 480	°F
Processing (Melt) Temp	440 to 480	°F
Mold Temperature	60 to 90	°F
Injection Pressure	200 to 800	psi
Injection Rate	Fast	
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	420 to 460	°F
Cylinder Zone 2 Temp.	420 to 460	°F
Cylinder Zone 3 Temp.	420 to 460	°F
Cylinder Zone 4 Temp.	420 to 460	°F
Cylinder Zone 5 Temp.	420 to 460	°F
Die Temperature	420 to 460	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² Die C, 20 in/min

³ Type 1